

Split Fresh

Work Order ID 151312-2

151312

Page 1

Tuesday, September 20, 2016 3:43:47 PM

Item ID: D4812-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Patient Stop Assembly

Start Date: 9/21/2016 Start Qty: ~~10.00~~

10

Cust Item ID:

Required Date: 9/28/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: Em

Date: 10/09/20

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4812

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.45

FLOW CNC Waterjet

1- Cut D4812-1F as per Dwg

Dwg Rev: 3

Prog Rev: 3

2- DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.02

Quality Control

10

10/10/2016

10

10/10/2016

151312

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N900040100

Stop *NS2*

10

10

Reference:

Run Start *NR1*

Stop *NR2*

[illegible]

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151312

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Required Date: 9/28/2016 Req'd Qty: 10.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.23

Hand Finishing

(x10) ϕ 2016/09/27
323

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.02

Quality Control

10 ϕ 16-09-27. D4S 34 9-89

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

170

Powdercoat

Memo

0.12

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:10
320
10:40

10 ϕ 16-09-27. D4S 34 9-89

Work Order ID 151312

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Item ID: D4812-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Patient Stop Assembly
 Start Date: 9/21/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 9/28/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.02				<u>10</u>			DAS 38 9-28 SEP 27 2016
190 *190* Small Fab Small Fab	Memo ASSEMBLE AS PER DWG	0.00 0.40				<u>6</u>	<u>88</u>		OCT 12 2016
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.03				<u>6</u>			DAS 38 9-28 OCT 14 2016

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Item ID: D4812-041

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Setup Start

NS1

Revision ID:

Stop

NS2

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Start Date: 9/21/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 9/28/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>ST200</u>	0.00							
210									
Packaging	Memo	0.02							
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.17							
Quality Control									

6 OCT 17 2016DAS
6
9-89DAS
21
9-89

OCT 18 2016

DAS
21
9-89

OCT 17 2016

Picklist Print

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Page 1

Work Order ID: 151312

151312

Parent Item: D4812-041

D4812-041

Parent Item Name: Patient Stop Assembly

Start Date: 9/21/2016

Required Date: 9/28/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 13.05.21 AS PER DWG REV.A VERF:JLM IPP
REV:B 16.04.19 AS PER DWG REV.B VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2690-6		Manufactured	No				Each	17.0000		20			
D2690-6									**		FF	OCT 12 2016	
Lanyard													

Location

Loc Qty

Loc Code

ST009

151007

17

144944

1

147589

16

D4811-1		Manufactured	No				Each	8.0000		20			
D4811-1									**		FF	OCT 12 2016	
Pin, Quick Release													

Location

Loc Qty

Loc Code

GA

2151526

8

138584

8

M6061T6S.063		Purchased	No			100	sf	251.6600	2.03	21.36842			
M6061T6S 063									**				
6061-T6 .063 Sheet													

Location

Loc Qty

Loc Code

MAT021

251.66

M133511

2.6

M134377

3.3

M134830

245.76

23

02/16/09/24

Picklist Print

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Work Order ID: 151312

151312

Parent Item: D4812-041

D4812-041

Parent Item Name: Patient Stop Assembly

Start Date: 9/21/2016

Required Date: 9/28/2016

Start Qty: 10.00

Required Qty: 10.00

MS21042L3

Purchased

No

Each

1,681.000

20

MS21042L3

Nut

FF

OCT 12 2016

Location

Loc Qty

Loc Code

FP001

7

M130922

7

GA

261

m134360

112

m135135

149

OVER007

600

m135530

600

ST303

813

m135407

270

m135600

543

291.0000

20

FF

OCT 12 2016

MS27039-1-07

Purchased

No

Each

MS27039-1-07

Screw

Location

Loc Qty

Loc Code

GA

270

125654

270

Return2016

1

m127813

1

ST281

20

m135015

20

82

10

Picklist Print

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Work Order ID: 151312

Parent Item: D4812-041

Parent Item Name: Patient Stop Assembly

151312

D4812-041

Start Date: 9/21/2016

Required Date: 9/28/2016

Start Qty: 10.00

Required Qty: 10.00

NAS1149D0332J

Purchased

No

Each

1,584.000

60

NAS1149D0332.J

Washer

FF

OCT 12 2016

Location

Loc Qty

Loc Code

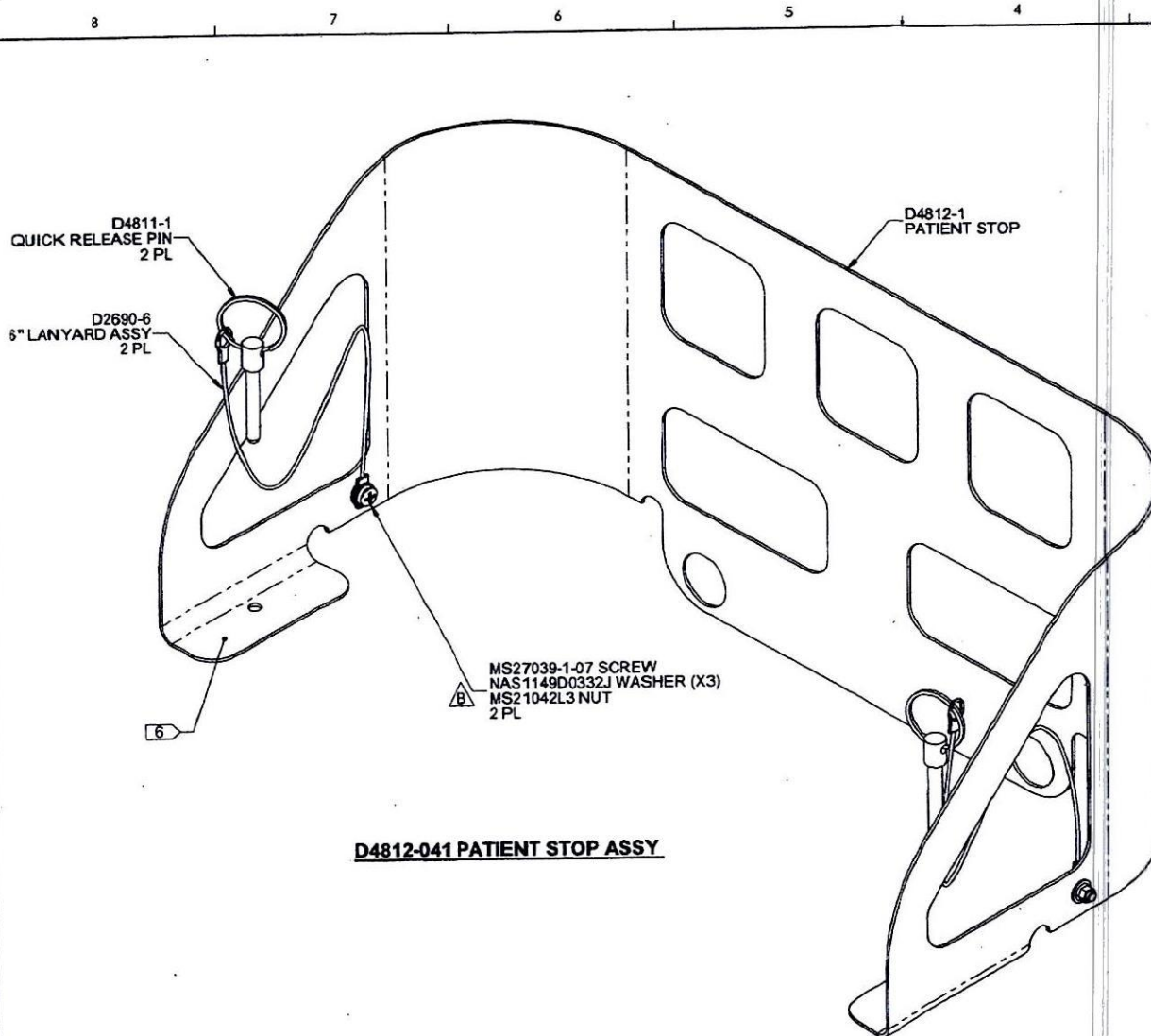
CA	6
m129682	6
FP001	204
m134848	204
GA	300
<u>m134848</u>	300
ST260a	600
m135672	600
ST264	474
m135536	31
m135566	443

364

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Shop Packet Print

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D4812-041 PATIENT STOP ASSY

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
 7) WEIGHT: 1.08 lbs

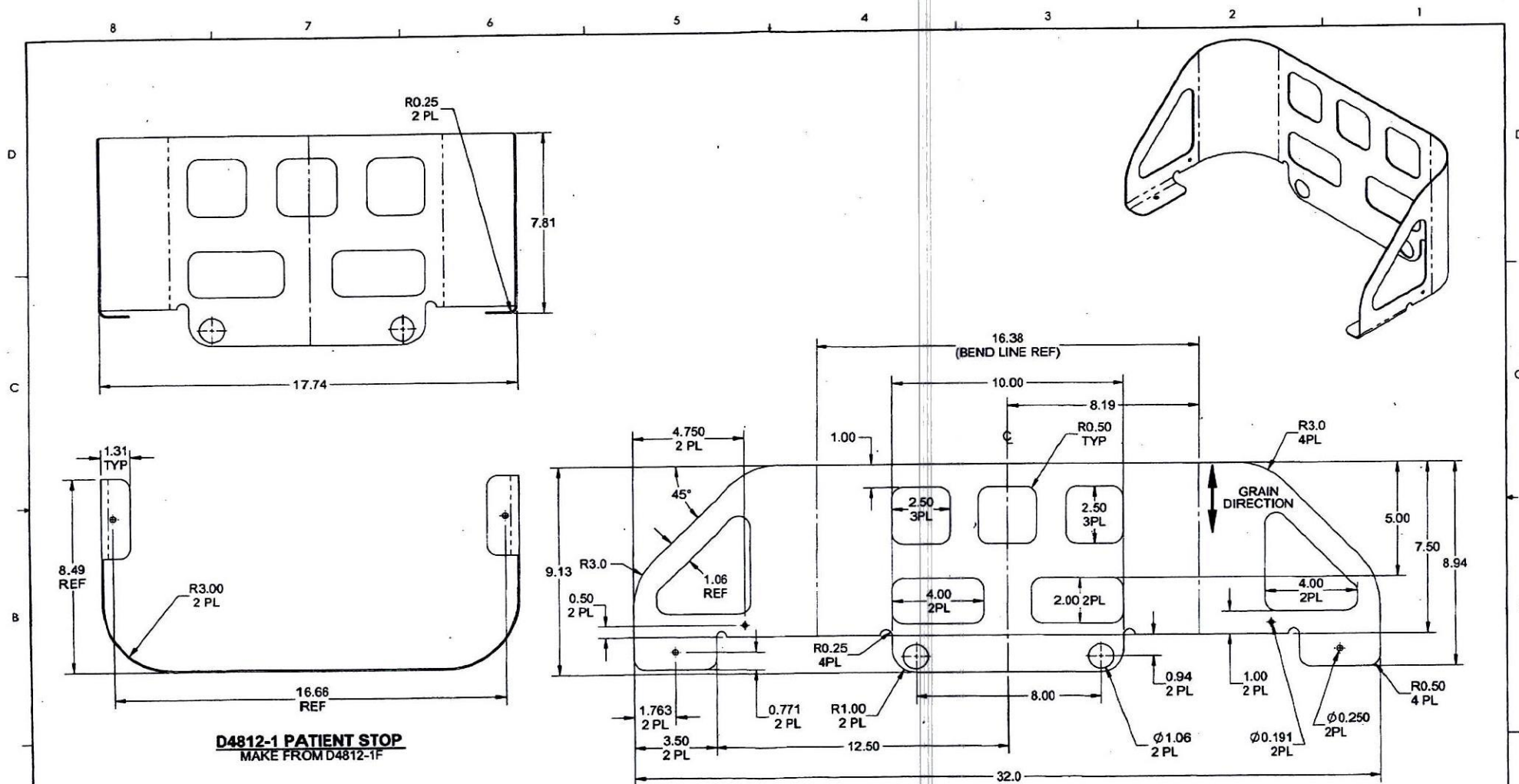
RELEASED
 2016-04-18
 ECW 16-082

ITEM	QTY	P/N	DESCRIPTION
	X	D4812-041	PATIENT STOP ASSEMBLY
1	2	D2690-6	6" LANYARD ASSY
2	2	D4811-1	QUICK RELEASE PIN
3	1	D4812-1	PATIENT STOP
4	2	MS21042L3	NUT, SELF-LOCKING
5	2	MS27039-1-07	SCREW, PAN-HEAD
6	6	NAS1149D0332J	WASHER

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 151312

Em 16/09/20

B	MS27039-1-07 WAS MS27039-1-13, REF. PAR13-292	MB	14.01.30
A	NEW ISSUE	DB	13.03.20
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	DD	D4812	SHEET 1 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	PATIENT STOP	NTS
DATE	14.01.30	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



NOTES:

- 1) MATERIAL: 6061-T6 SHEET, 0.063 THICK PER QQ-A-250/11, AMS-QQ-A-250/11, AMS 4025, AMS 4027 OR ASTM B209
REF: DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.04 lbs
- 8) PROFILE PER DRAWING FILE "D4812-1F-REVB.DXF".

RELEASED
2016-04-18

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	DD	D4812	SHEET 2 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	PATIENT STOP	NTS
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